

Work Order ID 143492

143492

Page 1

Tuesday, March 15, 2016 12:44:13 PM

Item ID: D4778-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stub Cover

Start Date: 3/31/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLD

Date: **MAR 15 2016**

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4778	B

100 0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

DAS
07
9-89

105

0.00

105

HandThermo

Dry Material

Memo

0.01

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 245 deg. F

MAR 23 2016

Time IN: 5:00 PM

6:00 AM

Time OUT:

Per W.L.

DAS
07
9-89

16/03/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Tuesday, March 15, 2016 12:44:14 PM

Item ID: D4778-1

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stub Cover

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Standards
110		0.00							DAS 07 9-89
110						12			16/03/23
Thermoform	Memo	0.01							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA153 using tool DT9887 Dwg Rev: <u>B.</u> Folio Rev: <u>B.</u> Visually inspect for proper formation and texture								
140		0.00							DAS 07 9-89
140						12			16/03/23
HandThermo	Memo	0.01							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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☐ OTHER : _____					

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Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/31/2016 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 4/8/2016 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamps

QC2- Inspect parts off machine FAI/FAIB

0.00

150

OC

Memo

0.00

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: Sf224B 0.00

0.00

170

Packaging

Memo

0.00

Packaging

DA
8
9-89

MAR 24 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Page 4

Item ID: D4778-1

Accept

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Revision ID:

Stop ***NS2***

Item Name: Stub Cover

Start Date: 3/31/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.02

Quality Control

MCS MAR 24 2016

MCS MAR 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : ☐									

Picklist Print

Tuesday, March 15, 2016 12:44:13 PM

Page 1

Work Order ID: 143492

143492

Parent Item: D4778-1

D4778-1

Parent Item Name: Stub Cover

Start Date: 3/31/2016

Required Date: 4/8/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: Rev. A New Issue 13/03/12 DL
Relaxed Tolerances on Dwg. 13/05/23 DL

Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased				100	sf	945.2934	2	21.05263			DAS 07 9-89

MI FXS 093-F6006-02

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

therm

m127208

945.29337

945.29337

24 sg P1

16/03/23

DQA: _____ Date: _____

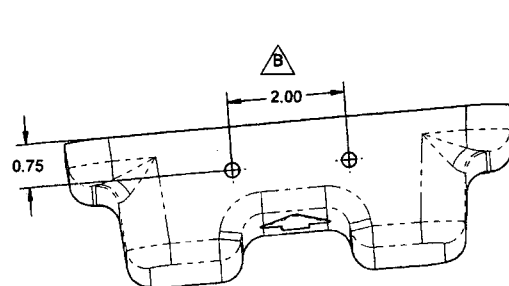


WORK ORDER NON-CONFORMANCE / UPDATE

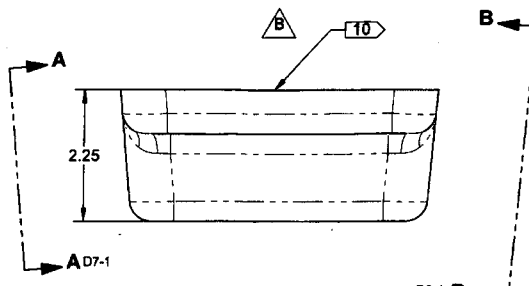
QA Closed: _____ Date: _____

Work Order update only ☐

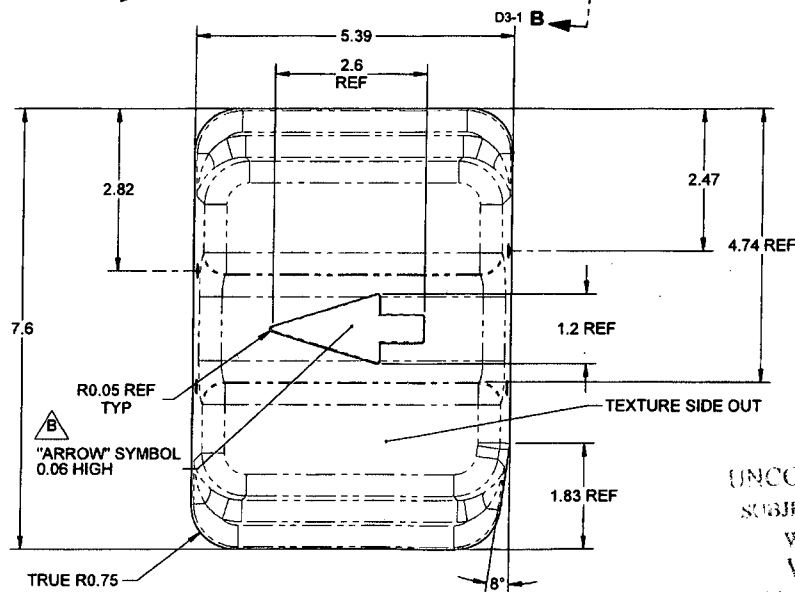
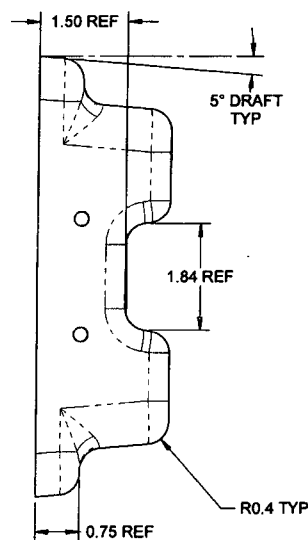
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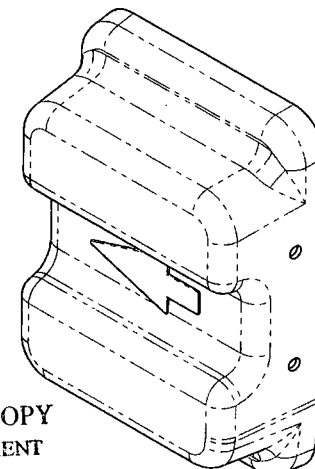
VIEW A-A D6-1



VIEW B-B D4-1



D4778-1 STUB COVER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 143492 MWS 16-0315

- NOTES:
- 1) MATERIAL: MLEXS.093-F6006-02 (LEXAN POLYCARBONATE, BLACK, .093")
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4778-1" AND B/N PER DART QSI 044 METHOD 6.4
 - 7) WEIGHT: 0.34 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9887 PER QSI 022. TRIM PER MOLD.
 - 9) MINIMUM MATERIAL THICKNESS AFTER FORMING IS 0.040"
 - 10) BOTTOM EDGE MAY BE TRIMMED, AS REQUIRED, TO ACCOMMODATE VARIATIONS IN FLOOR SURFACE

B	DIMENSIONAL TOLERANCES RELAXED (ZN D2-1, ZN D3-1, ZN D7-1), ADD TRIM NOTE 10 (ZN D5-1), ADD ARROW (ZN B6-1)	DB	13.04.03
A	NEW RELEASE	DB	13.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	DB	D4778	SHEET 1 OF 1
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	STUB COVER	NTS
DATE	13.04.03	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	